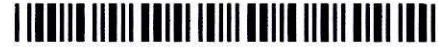




Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2562-001**  
**Job Sheet 208024**



253410

Part No: D2562-001

Job Qty: 2 pcs

Part Name: Strut 19.68"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/9/20

Job Tracking No:

Due Date: 4/8/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV D IPP F 02.04.15 Added dwg Rev.B1 NG

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation            | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off     |
|-------|----------------------|-------|------------|----------|-----------|---------|-----------------------------|-----------|--------------|
|       |                      |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |              |
| 100   | Small Fab - Brake NC | 2 pcs | 4/8/20     |          | 0.25      | 0.53    | Small Fab - Brake - 1       |           | GP 20-04-08. |
|       |                      |       |            |          |           |         | Small Fab - Brake - 2       |           |              |
|       |                      |       |            |          |           |         | Small Fab - Brake - 3       |           |              |
| 110   | Small Fab - 2 - B4B  | 2 pcs | 4/8/20     |          | 0.00      | 0.48    | Small Fab - 1 - B4B         |           | GP 20-04-08. |
|       |                      |       |            |          |           |         | Small Fab - 2 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 3 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 4 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 5 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 6 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 7 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 8 - B4B         |           |              |
|       |                      |       |            |          |           |         | Small Fab - 9 - B4B         |           |              |
| 120   | QC 5                 | 2 pcs | 4/8/20     |          | 0.00      | 0.00    | Small Fab - Various 1 - B4B |           |              |
|       |                      |       |            |          |           |         | QC 5 - 10                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 12                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 17                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 18                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 19                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 22                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 24                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 3                    |           |              |
|       |                      |       |            |          |           |         | QC 5 - 43                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 49                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 51                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 58                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 68                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 9                    |           |              |
|       |                      |       |            |          |           |         | QC 5 - 50                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 30                   |           |              |
|       |                      |       |            |          |           |         | QC 5 - 40                   |           |              |



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL : 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S269606



Part: D2562-001

Job No: 208024

Serial No/Batch: S269606

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/08/20

Plex 3/9/20 2:24 PM Dart.Renwick.Jennifer

|                                        |          |        |           |                        |          |
|----------------------------------------|----------|--------|-----------|------------------------|----------|
| 130 Powdercoat - 2 White Gl(S)-<br>B4B | 2<br>pcs | 4/8/20 | 0.00 0.08 | QC 5 - 61              |          |
|                                        |          |        |           | QC 5 - 81              |          |
|                                        |          |        |           | Powdercoat - 1 - B4B   |          |
|                                        |          |        |           | Powdercoat - 2 - B4B   |          |
|                                        |          |        |           | Powdercoat - 3 - B4B   |          |
| START 11:45 OUT 1:00 FINISH 12:15.     |          |        |           | Powdercoat - 4 - B4B   | 20.04.14 |
| 140 QC 3                               | 2<br>pcs | 4/8/20 | 0.00 0.00 | QC 3 - 10              |          |
|                                        |          |        |           | QC 3 - 13              |          |
|                                        |          |        |           | QC 3 - 15              |          |
|                                        |          |        |           | QC 3 - 17              |          |
|                                        |          |        |           | QC 3 - 18              |          |
|                                        |          |        |           | QC 3 - 2               |          |
|                                        |          |        |           | QC 3 - 28              |          |
|                                        |          |        |           | QC 3 - 3               |          |
|                                        |          |        |           | QC 3 - 30              |          |
|                                        |          |        |           | QC 3 - 34              |          |
|                                        |          |        |           | QC 3 - 36              |          |
|                                        |          |        |           | QC 3 - 41              |          |
|                                        |          |        |           | QC 3 - 51              |          |
|                                        |          |        |           | QC 3 - 58              |          |
|                                        |          |        |           | QC 3 - 59              |          |
|                                        |          |        |           | QC 3 - 68              |          |
|                                        |          |        |           | QC 3 - 9               |          |
|                                        |          |        |           | QC 3 - 40              |          |
|                                        |          |        |           | QC 3 - 19              |          |
|                                        |          |        |           | QC 3 - 43              |          |
|                                        |          |        |           | QC 3 - 24              |          |
|                                        |          |        |           | QC 3 - 61              |          |
|                                        |          |        |           | QC 3 - 81              |          |
|                                        |          |        |           | QC 3 - 82              |          |
| 150 Packaging 3-1 - Stock - B4B        | 2<br>pcs | 4/8/20 | 0.00 0.00 | Packaging 3 - 1 - B4B  |          |
|                                        |          |        |           | Packaging 3 - 2 - B4B  |          |
|                                        |          |        |           | Packaging 3 - 3 - B4B  |          |
|                                        |          |        |           | Packaging 3 - 10 - B4B |          |
|                                        |          |        |           | Packaging 3 - 11 - B4B |          |
|                                        |          |        |           | Packaging 3 - 12 - B4B |          |
|                                        |          |        |           | Packaging 3 - 13 - B4B |          |
|                                        |          |        |           | Packaging 3 - 14 - B4B |          |
|                                        |          |        |           | Packaging 3 - 15 - B4B |          |
|                                        |          |        |           | Packaging 3 - 16 - B4B |          |
|                                        |          |        |           | Packaging 3 - 17 - B4B |          |
|                                        |          |        |           | Packaging 3 - 18 - B4B |          |
|                                        |          |        |           | Packaging 3 - 19 - B4B |          |
|                                        |          |        |           | Packaging 3 - 20 - B4B |          |
|                                        |          |        |           | Packaging 3 - 21 - B4B |          |
|                                        |          |        |           | Packaging 3 - 22 - B4B |          |
|                                        |          |        |           | Packaging 3 - 23 - B4B |          |
|                                        |          |        |           | Packaging 3 - 24 - B4B |          |
|                                        |          |        |           | Packaging 3 - 25 - B4B |          |
|                                        |          |        |           | Packaging 3 - 26 - B4B |          |
|                                        |          |        |           | Packaging 3 - 27 - B4B |          |
|                                        |          |        |           | Packaging 3 - 28 - B4B |          |
|                                        |          |        |           | Packaging 3 - 29 - B4B |          |
|                                        |          |        |           | Packaging 3 - 30 - B4B |          |
|                                        |          |        |           | Packaging 3 - 31 - B4B |          |
|                                        |          |        |           | Packaging 3 - 32 - B4B |          |
|                                        |          |        |           | Packaging 3 - 33 - B4B |          |
|                                        |          |        |           | Packaging 3 - 34 - B4B |          |
|                                        |          |        |           | Packaging 3 - 35 - B4B |          |

8 pcs.  
MK

DAS  
28  
9-89

Plex 3/9/20 2:24 PM Dart.Renwick.Jennifer

DAS 34 9-89

DAS 59 9-89

DAS  
28  
9-89

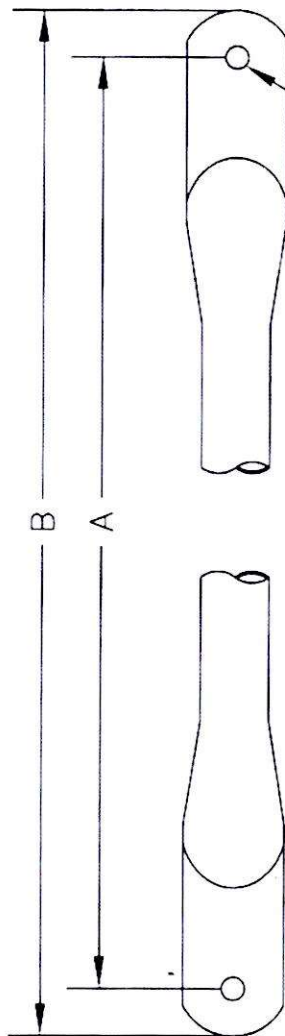
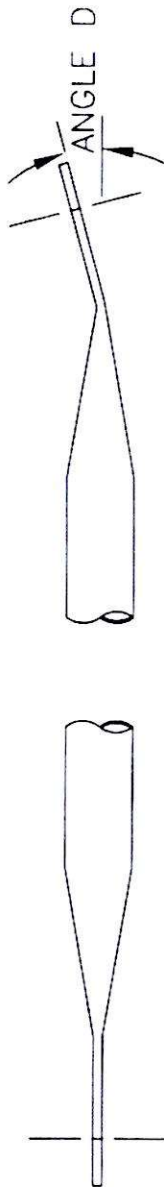
|                                                                                                                                                                                                                                                                                                                                                                                                                                              |                             |                       |                          |                        |                   |             |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-----------------------|--------------------------|------------------------|-------------------|-------------|
| 160 QC 21 - SA                                                                                                                                                                                                                                                                                                                                                                                                                               | 2<br>pcs                    | 4/8/20                | 0.00 0.00                | Packaging 3 - 37 - B4B | DAS<br>21<br>9-08 | APR 15 2020 |
| Part Op 100 - Punch ends and deburr as per dwg)Punch to length as per Dwg D2562<br>Descriptions: 110 - Small Fab)1- Bend end as per Dwg D2562 Angle "D"<br>120 - (QC5- Inspect part completeness to step on W/O)<br>130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: _____<br>140 - QC3- Inspect Part Finish)<br>150 - (Identify as per dwg & Stock Location: _____)<br>160 - (QC21- Final Inspection - Work Order Release) |                             |                       |                          |                        |                   |             |
| <b>Job BOM</b>                                                                                                                                                                                                                                                                                                                                                                                                                               |                             |                       |                          |                        |                   |             |
| <b>Part / Item</b>                                                                                                                                                                                                                                                                                                                                                                                                                           | <b>Component Name</b>       | <b>Quantity</b>       | <b>Operation</b>         | <b>Container</b>       |                   |             |
| M304TR0.500W.035                                                                                                                                                                                                                                                                                                                                                                                                                             | 304 Round Tube .500 X .035W | 3.4134 ft (1.7067 ea) | 100-Small Fab - Brake NC |                        |                   |             |
| <b>Job Allocations</b>                                                                                                                                                                                                                                                                                                                                                                                                                       |                             |                       |                          |                        |                   |             |
| <b>Operation</b>                                                                                                                                                                                                                                                                                                                                                                                                                             | <b>Component Part</b>       | <b>Required</b>       | <b>Inventory</b>         | <b>Allocated</b>       |                   |             |
| 100-Small Fab - Brake NC                                                                                                                                                                                                                                                                                                                                                                                                                     | M304TR0.500W.035            | 3                     | 58                       | 0                      |                   |             |
| <b>Part Specifications</b>                                                                                                                                                                                                                                                                                                                                                                                                                   |                             |                       |                          |                        |                   |             |
| Specifications could not be found.                                                                                                                                                                                                                                                                                                                                                                                                           |                             |                       |                          |                        |                   |             |

Plex 3/9/20 2:24 PM Dart.Renwick.Jennifer



**DART**

|                        |                         |                                                   |                        |
|------------------------|-------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>CP           | DRAWN BY<br>RF          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D2562                              | REV. D<br>SHEET 1 OF 1 |
| DATE<br>05.05.18       | TITLE<br>STRUT          |                                                   | SCALE<br>1:2           |
| A                      | 96.05.01                | NEW ISSUE                                         |                        |
| B                      | 98.10.15                | UPDATED MATERIAL NOTE (TSR A603)                  |                        |
| C                      | 02.06.05                | ADD -005; ADD FINISH                              |                        |
| D                      | 05.05.18                | ADD -007/-011/-013; UPDATE -005                   |                        |



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

| PART #    | DIM A | DIM B | DIA C | ANG D |
|-----------|-------|-------|-------|-------|
| D2562-001 | 19.68 | 20.48 | -     | 10    |
| D2562-003 | 20.37 | 21.17 | -     | 18    |
| D2562-005 | 29.00 | 29.80 | -     | 30    |
| D2562-007 | 19.22 | 20.02 | -     | 0     |
| D2562-011 | 25.79 | 26.59 | -     | 16    |
| D2562-013 | 26.63 | 27.43 | -     | 24    |
|           |       |       |       |       |
|           |       |       |       |       |
|           |       |       |       |       |
|           |       |       |       |       |

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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 208024

- GENERAL NOTES
- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035)  
ENSURE SEAMLESS TUBE IS USED
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                        |              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                        | MRB (QSI042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |